



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2571
Job Sheet 165331



Part No: D2571

Job Qty: 8 ea

Part Name: Saddle, Fwd, Out



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/30/17

Job Tracking No:

Due Date: 10/31/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV F IPP: I 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ

Ship Via:

Bill of Materials

Part/Part Name	Part Note	Serial No	Quantity	Location
D2571 Saddle, Fwd, Out	DWG REV F IPP: I 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ		0.000	
D6101-007 Saddle Billet	DWG REV B		0.000	

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	8 Ea	10/28/17	0.00	0.00	Start up container	
100	CNC Vertical Machining	8 pcs	10/30/17	0.57	17.78	HAAS 1	
110	Mill Conv	8 pcs	10/30/17	0.00	3.95	Mill Conv 1	
120	QC	8 pcs	10/30/17	0.00	0.00	QC14	
130	QC	8 pcs	10/30/17	0.00	0.00	QC8	mm L 17/11/17
140	HandFinish	8 pcs	10/30/17	0.00	0.35	HandFinish1	2017-11-06 JSL
150	Powdercoat	8 pcs	10/31/17	0.00	0.32	Powdercoat1	BR 17-11-17
160	QC	8 pcs	10/31/17	0.00	0.00	QC3	38
170	Packaging	8 pcs	10/31/17	0.00	0.00	Packaging3	SL 38 9-89
180	QC21-SA	8 Ea	10/31/17	0.00	0.00	QC21	

Part Op 100 - Program Batch No. _____ Double check by: _____ 1-Machine Step No 1 per Folio FA051 and inspect per Descriptions: attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect
110 - Machine keyway as per dwg D2571 & D2572
120 - Inspect on CMM as per folio CMM A022.
150 - START TIME: 8:50 FINISH TIME: 9:20 O.V.T: 320° M/B80W.

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D6101-007	8	0	0	0

Part Specifications

Specifications could not be found.

DART
AEROSPACE
S002181



Saddle, Fwd, Out

PART NO: D2571

Revision:

Operation:

Quantity:

Change No:

Start up Operation

8

Mfg Date: 10/26/17

Job No: 165331

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7

CANADA

TEL.: 1 613 632-5200

Email: sales@dartaero.com

www.dartaerospace.com

Work Order ID 165331

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165331

Page 1

Item ID: D2571

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, Fwd, Out

Start Date: 8/24/2017 Start Qty: 8.00

8

Cust Item ID:

Required Date: 9/1/2017 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: DAS 21 Date: AUG 22 2017 Tooling: _____ Date: _____
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2571	F								

100

3.70

100

HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

3.41

HAAS CNC vertical machine #1

Program Batch No. _____

Double check by: _____

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect

8FM17-11-02

110

0.00

110

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

1.60

Conventional Milling Machine

Machine keyway as per dwg D2571 & D2572

8FM17-11-02

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : ☐					

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Hand Finishing

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

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[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

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Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

Picklist Print

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Page 1

Work Order ID: 165331

165331

Parent Item: D2571

D2571

Parent Item Name: Saddle, Fwd, Out

Start Date: 8/24/2017

Required Date: 9/1/2017

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: I02.10.02Re-format; Change to Dwg Rev. D & incorporated
D2572KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-007		Manufactured	No			100	Each	10.0000	1	8			
D6101-007									**				
Saddle Billet													

Location

Loc Qty

Loc Code

MAT041

10

164013

10

8

SBL 17/10/25

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

DART AEROSPACE LTD	Work Order:	165331
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. F		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		0.440	0.438	0.438	0.438		
B	1.745	1.755		1.751	1.746	1.746	1.747		
C	3.495	3.505		3.505	3.498	3.499	3.498		
D	1.745	1.755		1.751	1.747	1.747	1.747		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		0.499	0.500	0.500	0.500		
G	0.257	0.262	0	0.2585	0.259	0.259	0.259		
H	0.375	0.380		0.3755	0.376	0.376	0.376		
I	0.490	0.510		0.502	0.502	0.499	0.500		
J	1.174	1.184		1.1795	1.179	1.180	1.178		
K	0.558	0.578		0.568	0.566	0.564	0.565		
L	1.174	1.184		1.1785	1.178	1.180	1.179		
M	1.490	1.500		1.4935	1.493	1.493	1.494		
N	2.495	2.505		2.4995	2.500	2.499	2.502		
O	3.869	3.879		3.872	3.873	3.873	3.873		
P	0.115	0.135		0.125	0.125	0.125	0.125		
Q	0.115	0.135		0.125	0.125	0.124	0.123		
R	0.240	0.260		0.255	0.256	0.254	0.254		
S	0.115	0.135		0.128	0.130	0.130	0.128		
T	0.178	0.198		0.1875	0.1875	0.1875	0.1875		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.2415	0.240	0.239	0.240		
W	0.115	0.135		0.123	0.1235	0.124	0.125		
X	0.308	0.313		0.312	0.312	0.312	0.312		
Y	0.760	0.765		0.763	0.762	0.762	0.762		
Z	0.352	0.372		0.363	0.364	0.364	0.364		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.624	0.626	0.626	0.624		
AC	0.053	0.073		0.060	0.063	0.063	0.063		
AD	0.240	0.260		0.252	0.253	0.252	0.250		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		0.133	0.132	0.133	0.130		
AG	0.240	0.280		0.247	0.254	0.255	0.255		
AH	0.240	0.260		0.258	0.253	0.252	0.256		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.032	0.033	0.034	0.033		

Accept/Reject

Measured by:	FM	Audited by:	DAS
Date:	17-11-02	Date:	49 12/11/07

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 165331
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	*5	*6	*7	*8		
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.748	1.748	1.748	1.748		
C	3.495	3.505		3.498	3.498	3.498	3.498		
D	1.745	1.755		1.748	1.748	1.748	1.748		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		0.500	0.501	0.500	0.501		
G	0.257	0.262	0	0.259	0.259	0.259	0.259		
H	0.375	0.380		0.377	0.377	0.377	0.377		
I	0.490	0.510		0.5005	0.498	0.5005	0.5005		
J	1.174	1.184		1.177	1.177	1.177	1.178		
K	0.558	0.578		0.566	0.565	0.567	0.566		
L	1.174	1.184		1.176	1.176	1.177	0.178		
M	1.490	1.500		1.492	1.493	1.494	1.494		
N	2.495	2.505		2.499	2.500	2.501	2.499		
O	3.869	3.879		3.874	3.875	3.875	3.875		
P	0.115	0.135		0.129	0.128	0.127	0.128		
Q	0.115	0.135		0.128	0.129	0.123	0.123		
R	0.240	0.260		0.251	0.253	0.252	0.253		
S	0.115	0.135		0.129	0.130	0.130	0.130		
T	0.178	0.198		0.1875	0.1875	0.1875	0.1875		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.239	0.243	0.243	0.241		
W	0.115	0.135		0.123	0.124	0.125	0.124		
X	0.308	0.313		0.312	0.312	0.312	0.312		
Y	0.760	0.765		0.762	0.762	0.763	0.762		
Z	0.352	0.372		0.364	0.364	0.364	0.364		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.626	0.627	0.625	0.625		
AC	0.053	0.073		0.062	0.063	0.063	0.063		
AD	0.240	0.260		0.256	0.253	0.254	0.253		
AE	1.375	1.395		1.388	1.388	1.387	1.388		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.250	0.250	0.250	0.250		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.035	0.035	0.035	0.035		

Accept/Reject

Measured by:	
Date:	

Audited by:	DAS
Date:	49 17/01/03 9-89

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	



